

shp April 13

Work Order ID 81186

81186

Page 1

March-12-12 8:41:03 AM

Item ID: D3914-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop *NS2*

Start Date: 09/03/2012 Start Qty: 2.00

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: HLT

Date: 12/03/12 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3914	B
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

12.04.11 (1x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

PC 12.04.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81186

March-12-12 8:41:03 AM

81186

Page 2

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 09/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 19/03/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		Sidouliz		(u)			
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 9:00 Oven Temperature: 320 °F Finish Time: 9:30	0.00 0.00							IX ϕ m-f 12/04/12
140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00 0.00							1 ϕ BL10-4-12

M117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				1	1		M 12/04/12
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location <u>D4030-241</u>	0.00							
160									
Packaging	Memo	0.00							8/4/11
Packaging									1 0 12/4-12
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							12/4/13
Quality Control									

Handwritten: 12-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-12-12 8:41:08 AM

Page 1

Work Order ID: 81186

81186

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

35.0000

2

4

D2581

Mounting Bracket

**

SAD 12-04-04

Location

Loc Qty

Loc Code

WA005

35

B81253

2

69739

1

70766

2

77045

3

77523

29

D3914-1

Manufactured

No

100

Each

0.0000

2

4

D3914-1

Rib

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA

2

B81407

(2)

WA006

-2

D3914-7

Manufactured

No

100

Each

2.0000

2

4

D3914-7

Rib

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA006

2

B81453

2

80164

2

D4016-3

Manufactured

No

100

Each

18.0000

3

6

D4016-3

Hinge Half, Lid

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA005

18

B81389

3

78495

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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March-12-12 8:41:08 AM

Page 2

Work Order ID: 81186

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 2.00

Required Qty: 2.00

D4018-5 Manufactured No

100 Each 7.0000 9 18

D4018-5

Rib

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA005

7

B81448

80597

7

B80776

D4020-5 Manufactured No

100 Each 1.0000

D4020-5

Mesh (350 Basket Long, Lid)

B82699 2

Location

Loc Qty

Loc Code

WA

1

78698

1

B81446 → 12-04-11

D4021-3 Manufactured No

100 Each 3.0000 1 2

D4021-3

Data Plate

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA005

3

75460

3

~~B80897~~

~~B81448~~

3.0000

1

2

B82507 → ①

D4035-041 Manufactured No

100 Each

D4035-041

Lid Rib Assembly, Fwd (350 Basket)

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA006

3

74642

3

B81450

①

D4035-043 Manufactured No

100 Each 1.0000

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA006

1

76545

1

B81452

①

March-12-12 8:41:08 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 3

March-12-12 8:41:08 AM

Work Order ID: 81186

81186

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: ~~2.00~~

Required Qty: 2.00

D2728-3

Manufactured No

140

Each

0.0000

1

~~2~~

D2728-3

Dart Logo label

115050

**

1

BR 12-11-12

Dart Aerospace Ltd

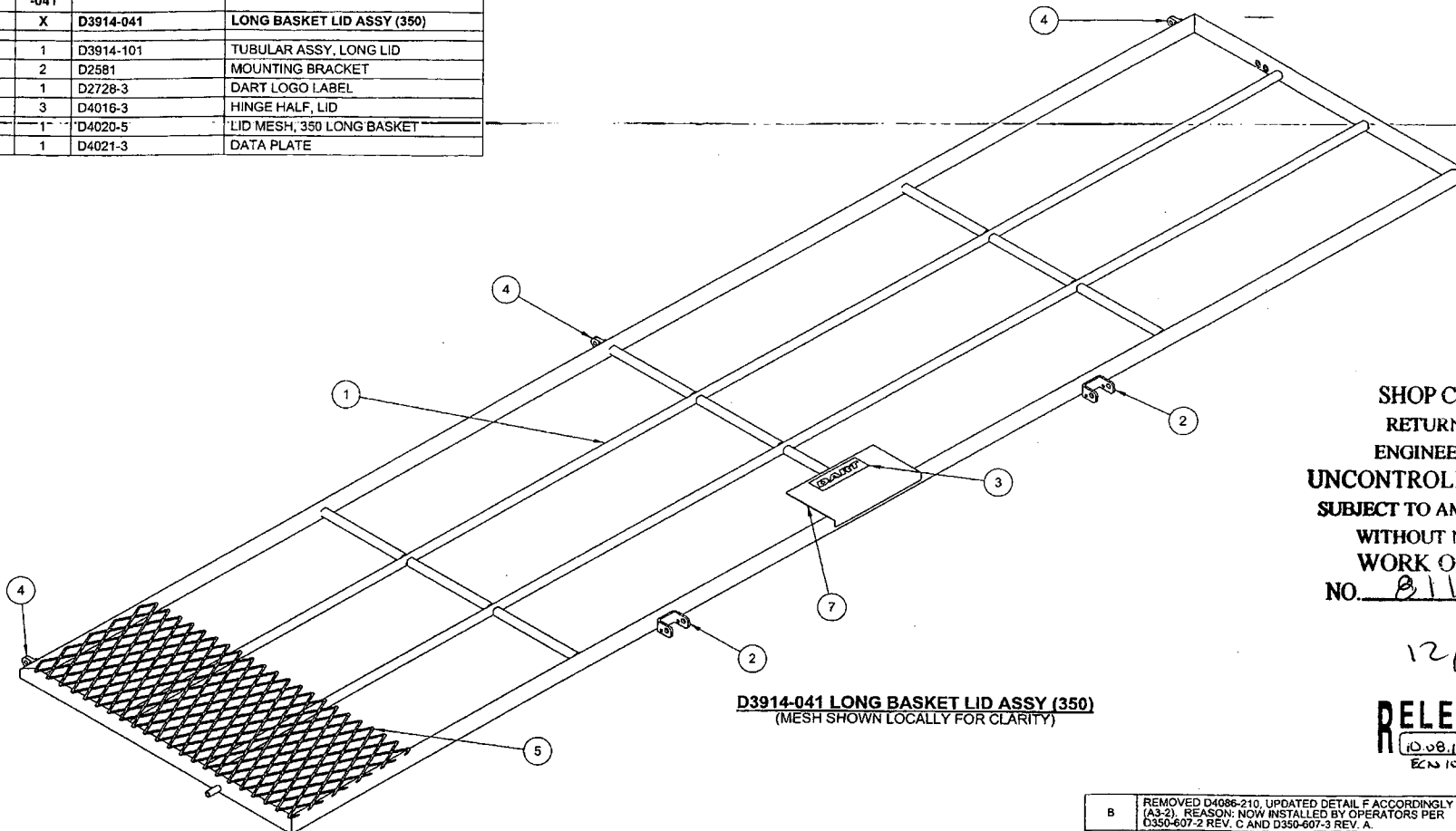
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81186
MLJ
12/03/12

RELEASED
10-08-17 9P
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ALS	DRAWING NO.	REV. B
CHECKED	ALS	D3914	SHEET 1 OF 4
MFG. APPR.	ALS	TITLE	SCALE
APPROVED	ALS	LONG BASKET LID ASSY (350)	NTS
DE APPR.	ALS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.08.05		

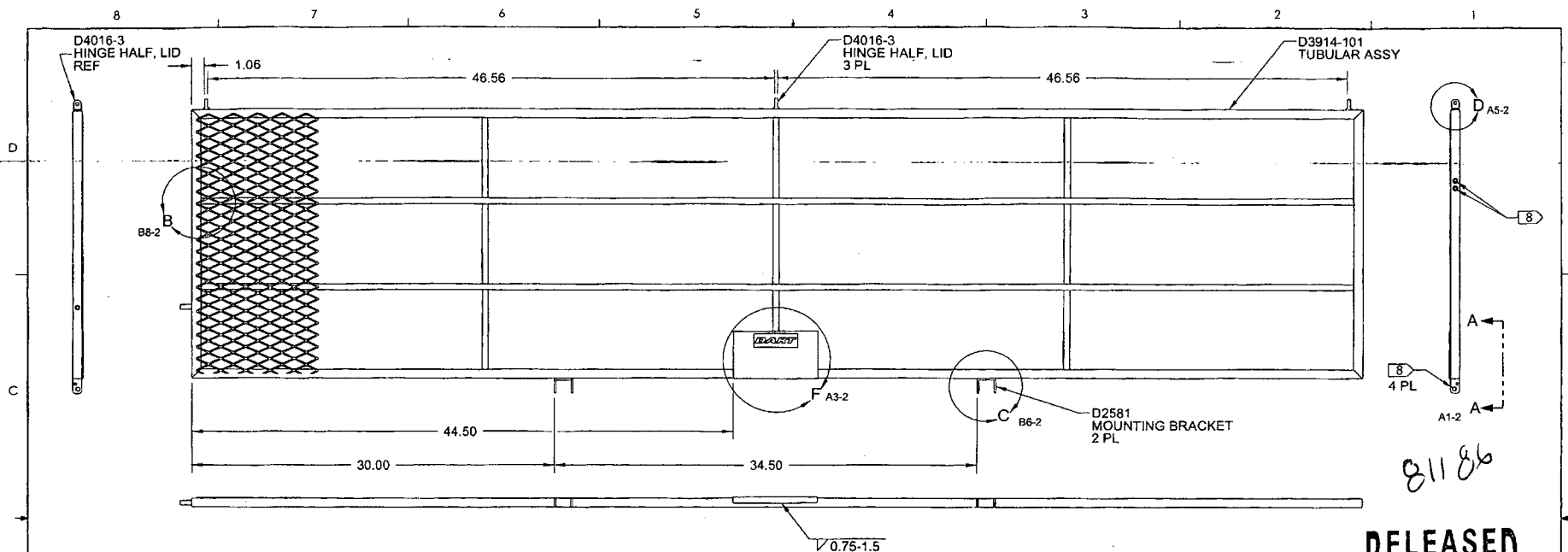
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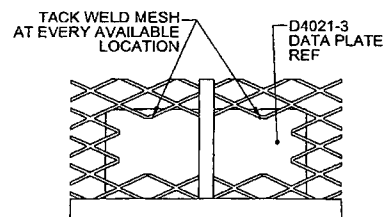
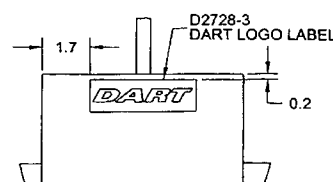
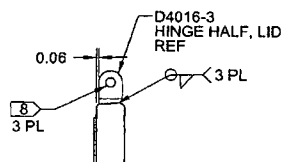
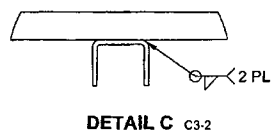
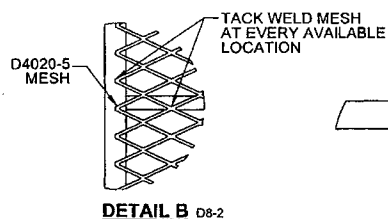
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 CP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3914	REV. B
CHECKED		SHEET 2 OF 4	
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET LID ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED OR REPRODUCED OR COPIED OR OTHERWISE DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

Dart Aerospace Ltd

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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3

81186

D4035-041
RIB ASSY, FWD



TYP

D3914-1
RIB
2 PL

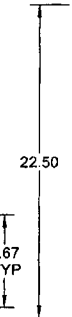
D4018-5
RIB
9 PL

D3914-7
RIB
2 PL

E C2-3
E

TYP

D4035-043
RIB ASSY, AFT



22.50

6.67
TYP

23.25
TYP

8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12 CP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D3914	SHEET 3 OF 4
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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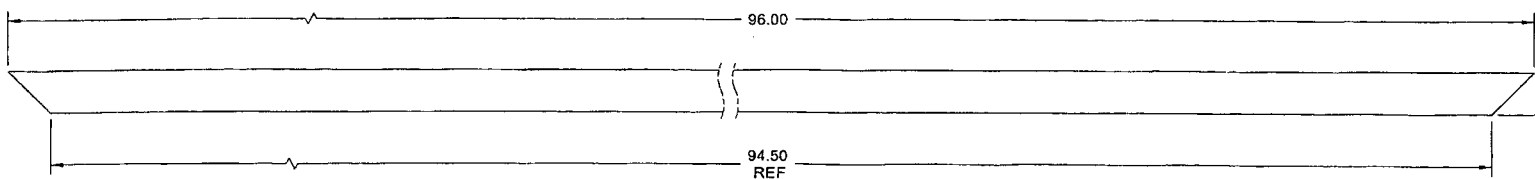
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

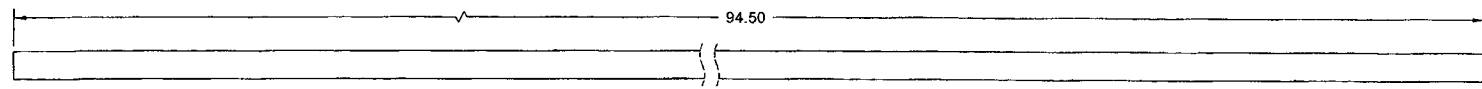
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81186



D3914-1 RIB



D3914-7 RIB

NOTES:
1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.05

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 4 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	WJ	LONG BASKET LID ASSY (350)	NTS
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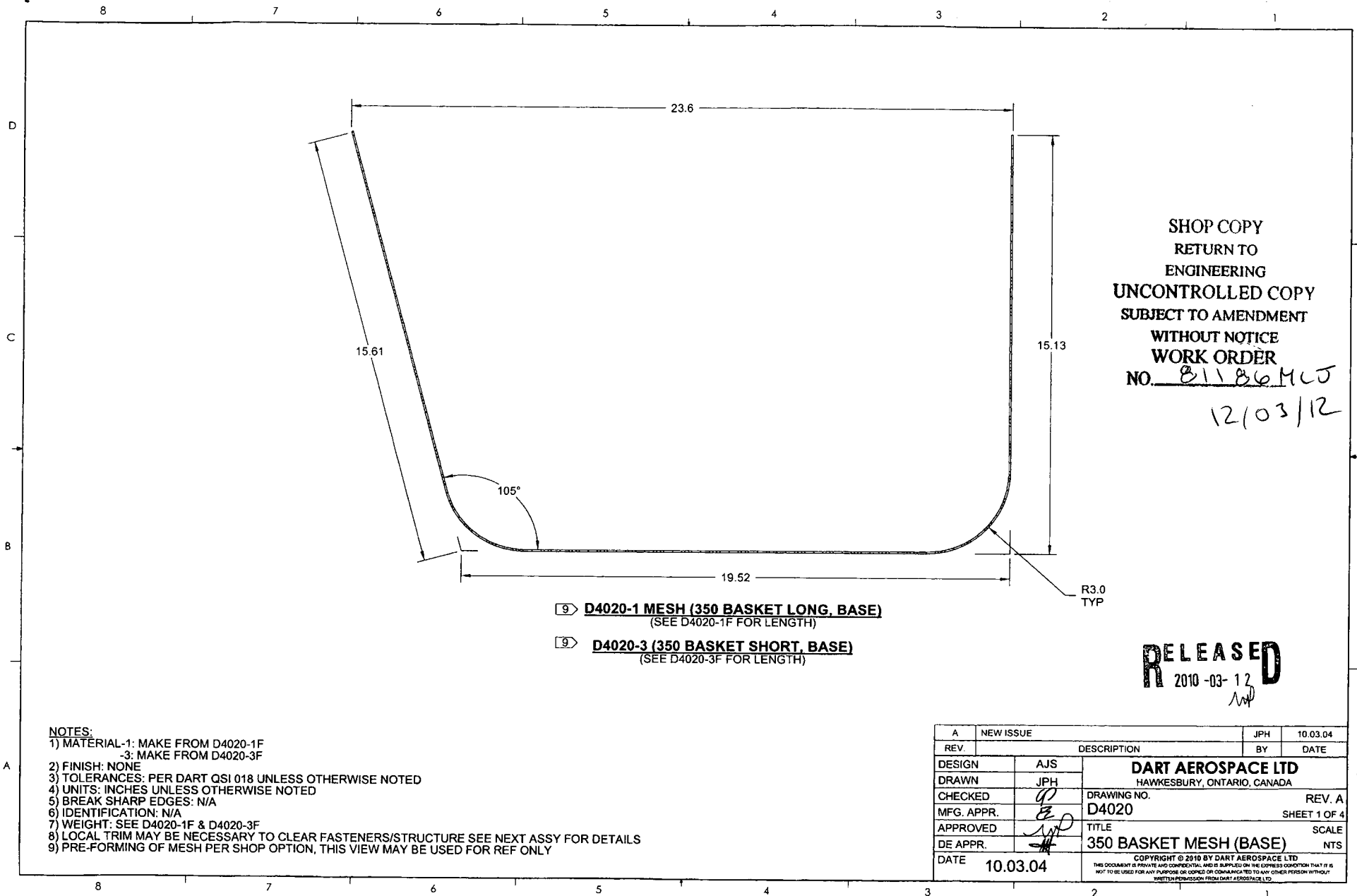
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NOTE: Date & initial all entries



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 81186 MCT
 12/03/12

- 9 D4020-1 MESH (350 BASKET LONG, BASE)
 (SEE D4020-1F FOR LENGTH)
- 9 D4020-3 (350 BASKET SHORT, BASE)
 (SEE D4020-3F FOR LENGTH)

RELEASED
 2010-03-12
AW

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F
 -3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

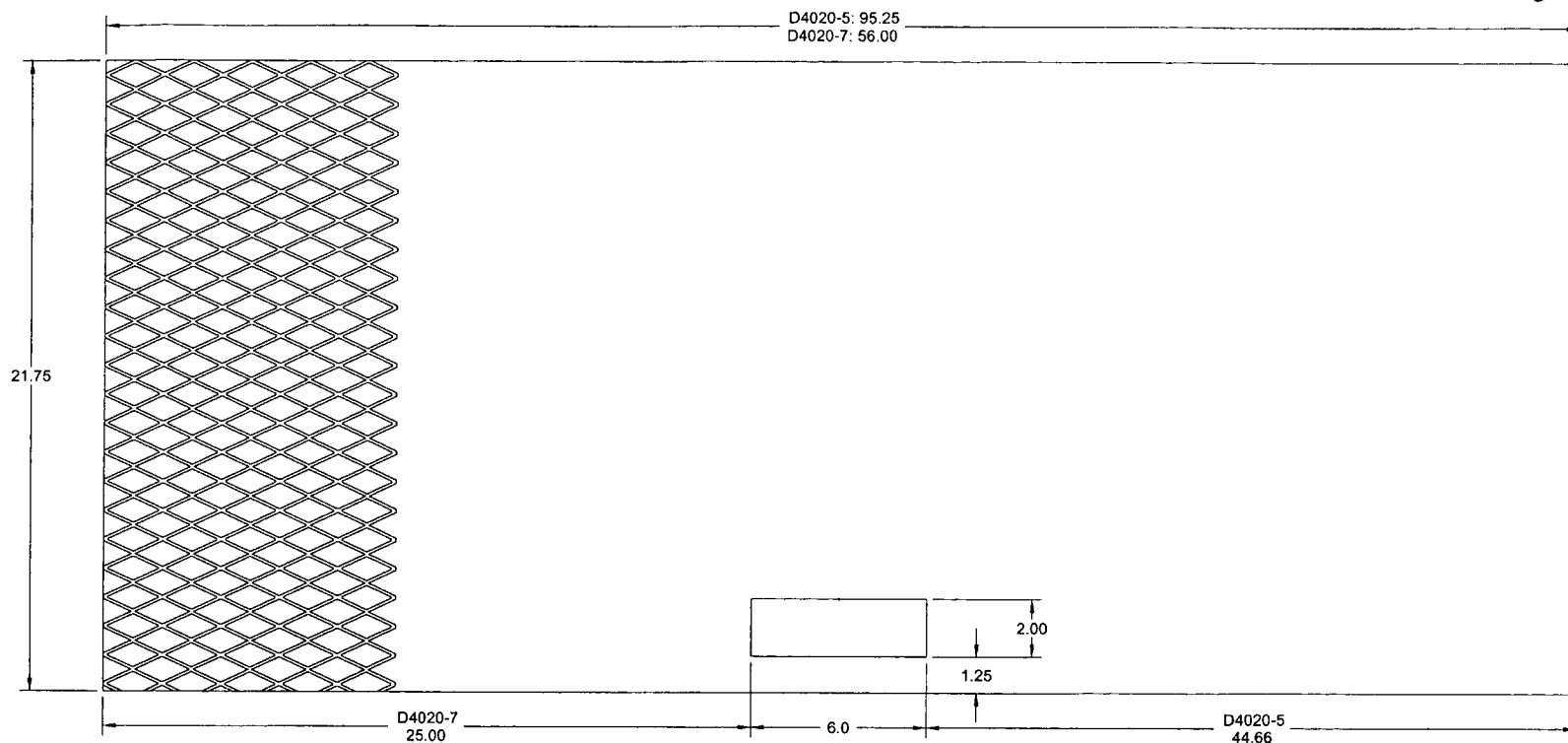
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

21186







9) **D4020-5 MESH (350 BASKET LONG, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9) **D4020-7 MESH (350 BASKET SHORT, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
m

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4020	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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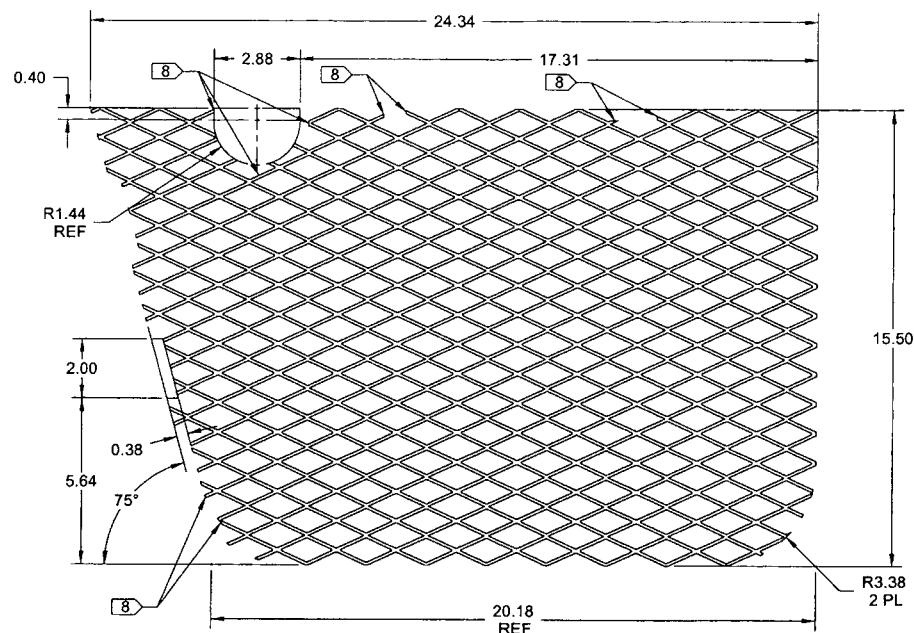
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4020	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries